

Date: Monday, 22/10/2007 2:17:15 PM
User: Linda Lacelle

Process Sheet

split (16)

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
Job Number : 35296-13
Estimate Number : 12882
P.O. Number :
This Issue : 22/10/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : SMALL /MED FAB
Previous Run : 35030
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07.05.24 EC
est rev B ECN 987 07.10.09 EC verified by: DD

Part Number : D3560042
Drawing Number : D3560 UNDER REVIEW
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 29/10/2007 Qty: 2 Um: 14 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total : 20.5065 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M106182

Inf 02/11/30

(14)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 16.750" long

Inf 02/11/30

(14)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: M & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

RF 07/12/06

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RF 07/12/06

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 02/12/07

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35296

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

PLATE

B 35331 ✓ SP 08.08.15 (2x)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch () SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

SP 08.08.15 (2x)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08.08.15 (2x)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 08.08.15 11/08/15 (2x)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SP 08.08.15 (2x)

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Drawing Name: ARM

Job Number: 35296

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.08.15 2

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Spacer

B 37113

20 08/08/18 (2)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

20 08/08/18 (2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.08.18 (2)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *MF*

08.08.28

16.0

QC21

FINAL INSPECTION/W/O RELEASE



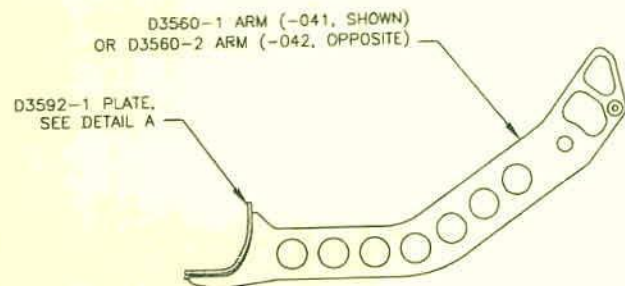
Comment: FINAL INSPECTION/W/O RELEASE

(2)
20/08/29

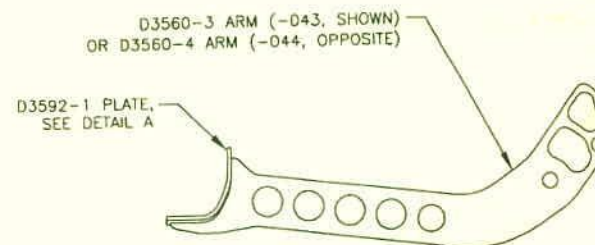
Job Completion



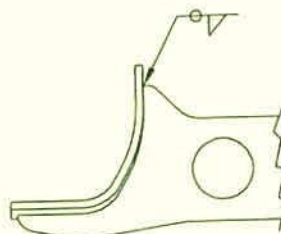
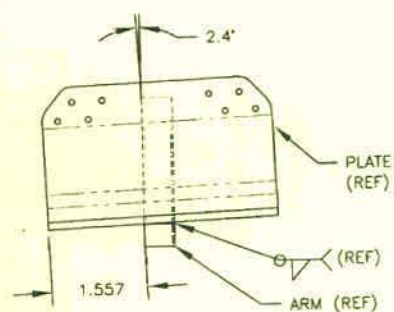
MF 08-08-28



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

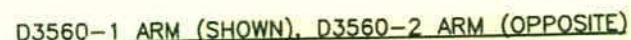
RELEASED
07.06.19
UNDER REVIEW
07.10.22 DC

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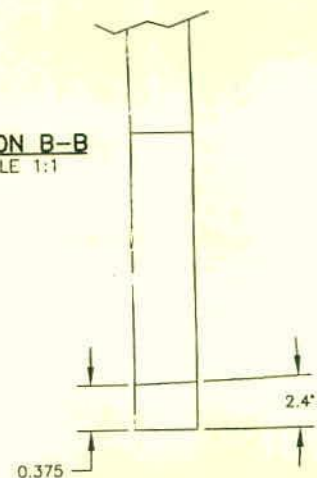
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	qj	DRAWN BY qj
CHECKED	H	APPROVED H
DATE	07.06.19	
		DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D3560
		TITLE ARM WELDMENT
		REV. C SHEET 1 OF 3 SCALE 1:4

W/O 3586



- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



RELEASED
07.06.29

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DESIGN

DRAWN BY

PART

DART AEROSPACE LTD.

HAMMISBURY, ONTARIO, CANADA

CHECK

APPROVED

DRAWING NO.	
-------------	--

REV. C

DATE _____

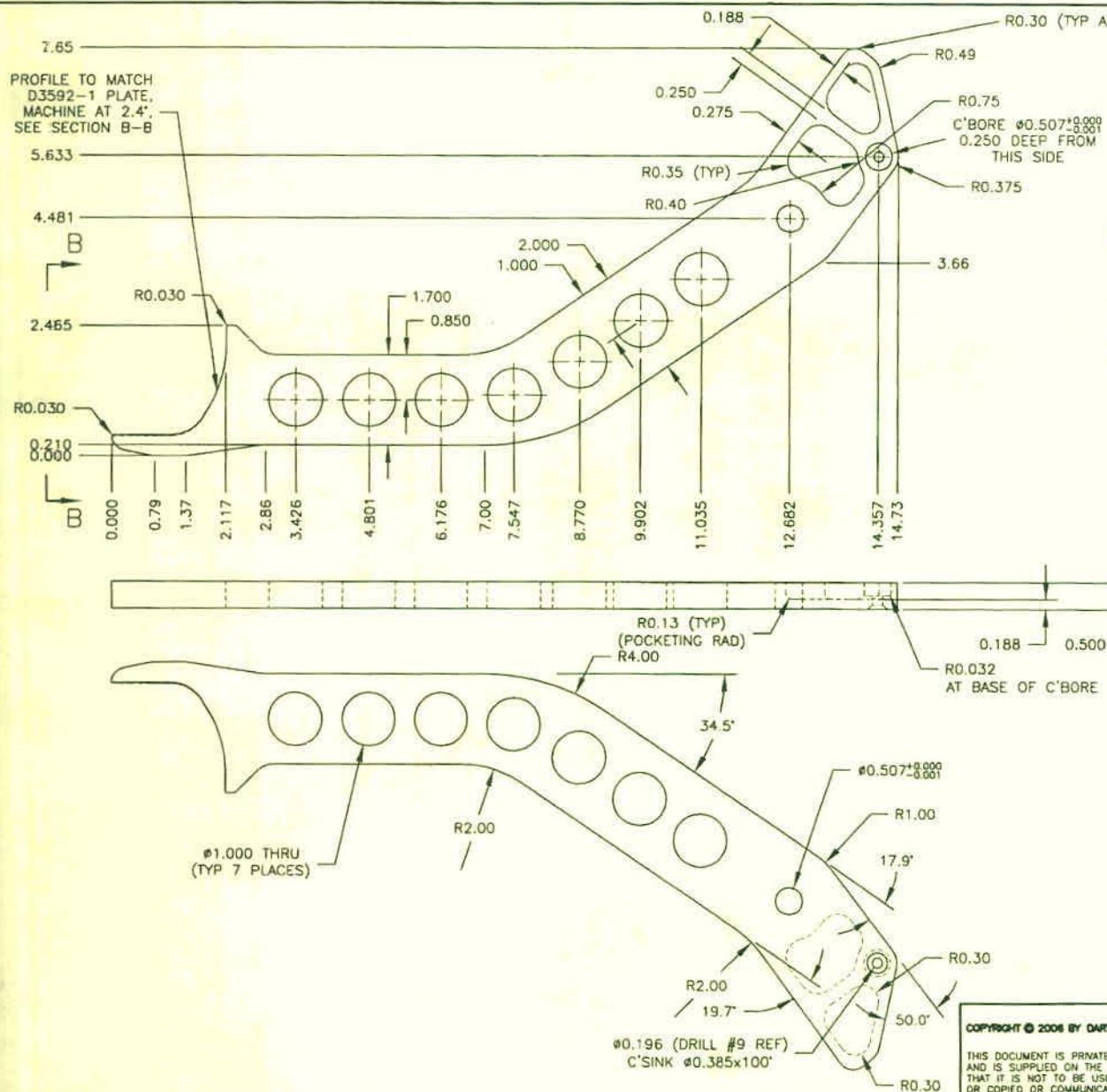
TITLE

ARM WELDMENT

SCALE

SHEET 2 OF 3

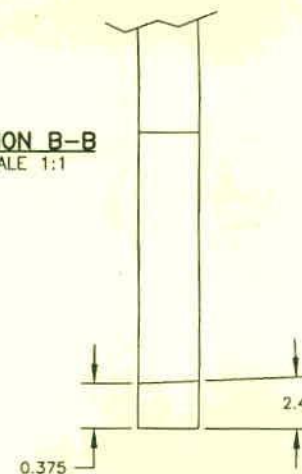
SCALE



D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B
SCALE 1:1

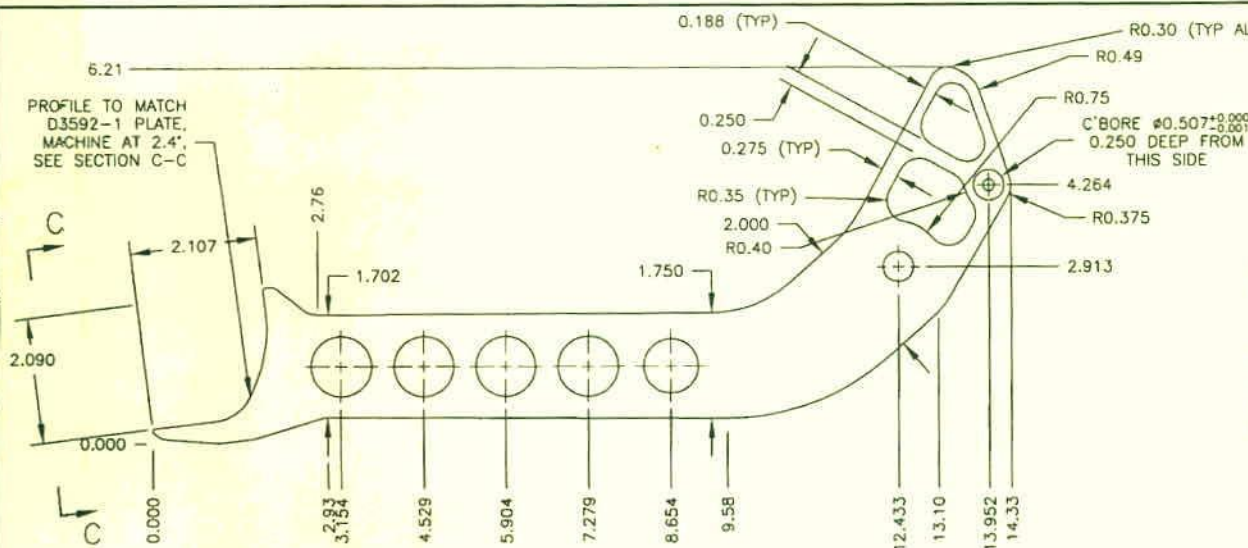


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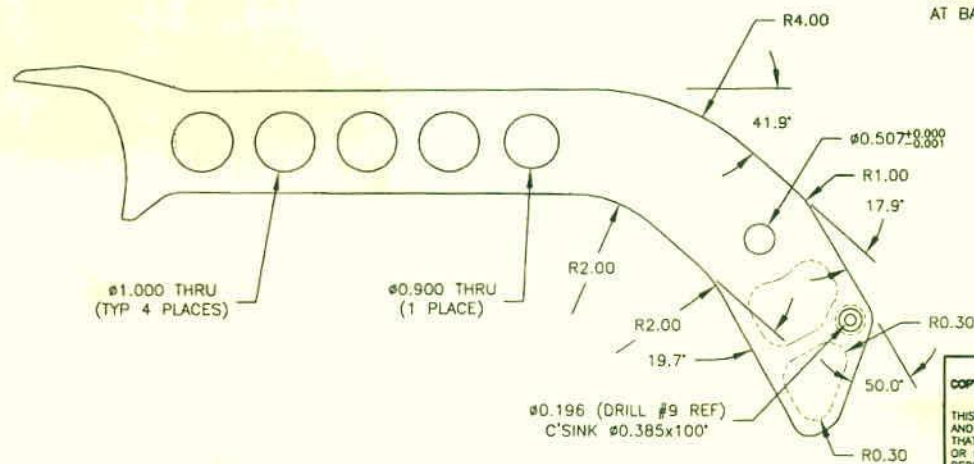
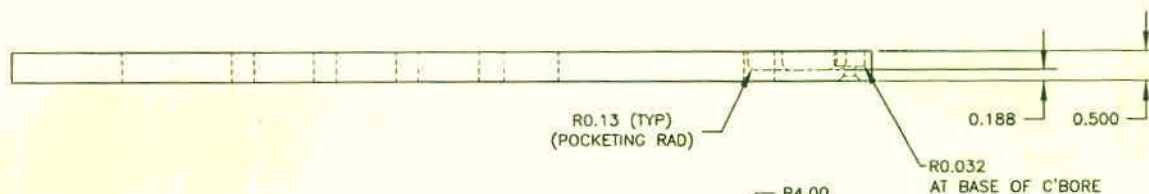
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CHECKED	df	APPROVED	df	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 2 OF 3
		SCALE	1:2		

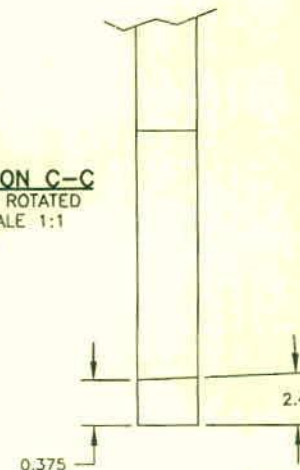


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



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CHECKED	gp	APPROVED	gp	DRAWING NO.	REV. C
DATE	07.06.19	TITLE	ARM WELDMENT	D3560	SHEET 3 OF 3
					SCALE 1:2

